Amendments to the Specification:

Please replace the paragraph 0042 on page 16 with the following amended paragraph:

To start the manufacturing process, a load is applied to the master alloy or the like which has been heated to have a surface temperature of 1,100 to 1,200° C. Due to exposure to external air, the temperature of the master alloy or the like drops while the load is applied. In due course, the surface temperature of the master alloy or the like reaches 950° C or below, but even then the load application is continued. Preferably, the surface temperature of the master alloy or the like is reduced to as low as possible, but not so low as to break the master alloy or the like. It should be borne in mind that the master alloy or the like tends to break at 700° C or below.

Please replace the paragraph 0043 on page 17 with the following amended paragraph:

For further grain refinement, a load is applied for as long as possible, with the temperature being kept at 950° C or below, preferably 850° C or below. During this forging, the temperature is allowed to drop to a lowest possible temperature at which the master alloy or the like does not break.